

Work Order ID 62711 -1

Wednesday, October 06, 2010 3:39:28 PM

Split



Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 10/6/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan:

Date: 10-06-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4154	A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH#: M116468

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: M107057

3-Transfer drill holes in bar

EL 10-1-6 (24)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PC 11-01-07

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

(24)

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112538

Memo

0.00

Powder Coating

START TIME *10:45*

OVEN TEMPERATURE *320°*

FINISH TIME *11:15*

H LR 11-01-10

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M 11/01/10

4 4

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Wednesday, October 06, 2010 3:39:28 PM



Page 3

Item ID: D4154-041

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Stop



Item Name: Wearplate Assembly

Start Date: 10/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

M116210

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

11 01 12 4

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

5 u/01/13

5 u/01/13

170

0.00



Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Packaging

FP-9

X-1 11 u/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 62711

Wednesday, October 06, 2010 3:39:28 PM

Page 4

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Start Date: 10/6/2010 Start Qty: 10.00

Required Date: 10/15/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/13 *[Signature]*
MF
11-01-13

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:39:33 PM

Page 1

Work Order ID: 62711

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1		Manufactured	No			100	Each	4.0000	1	10			
Plate													

B62708 x 4 EL 11-1-6

Location

Loc Qty

Loc Code

WA

4

62199

4

D4155-1		Manufactured	No			100	Each	5.0000	1	10			
Bar													

Location

Loc Qty

Loc Code

ST

5

60976

2

62198

3

62709

x 1

x 4

1

4 EL 11-1-6

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ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

SHOT ON
 RETURN
 ENGINE
 UNCONFIRMED
 SUBJECT TO
 WITHIN 10
 WORKING
 NO. 4274
 10-0-01

D4154-041 WEARPLATE ASSEMBLY

RELEASED
 2010-09-15
 MP

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4154	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small> COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

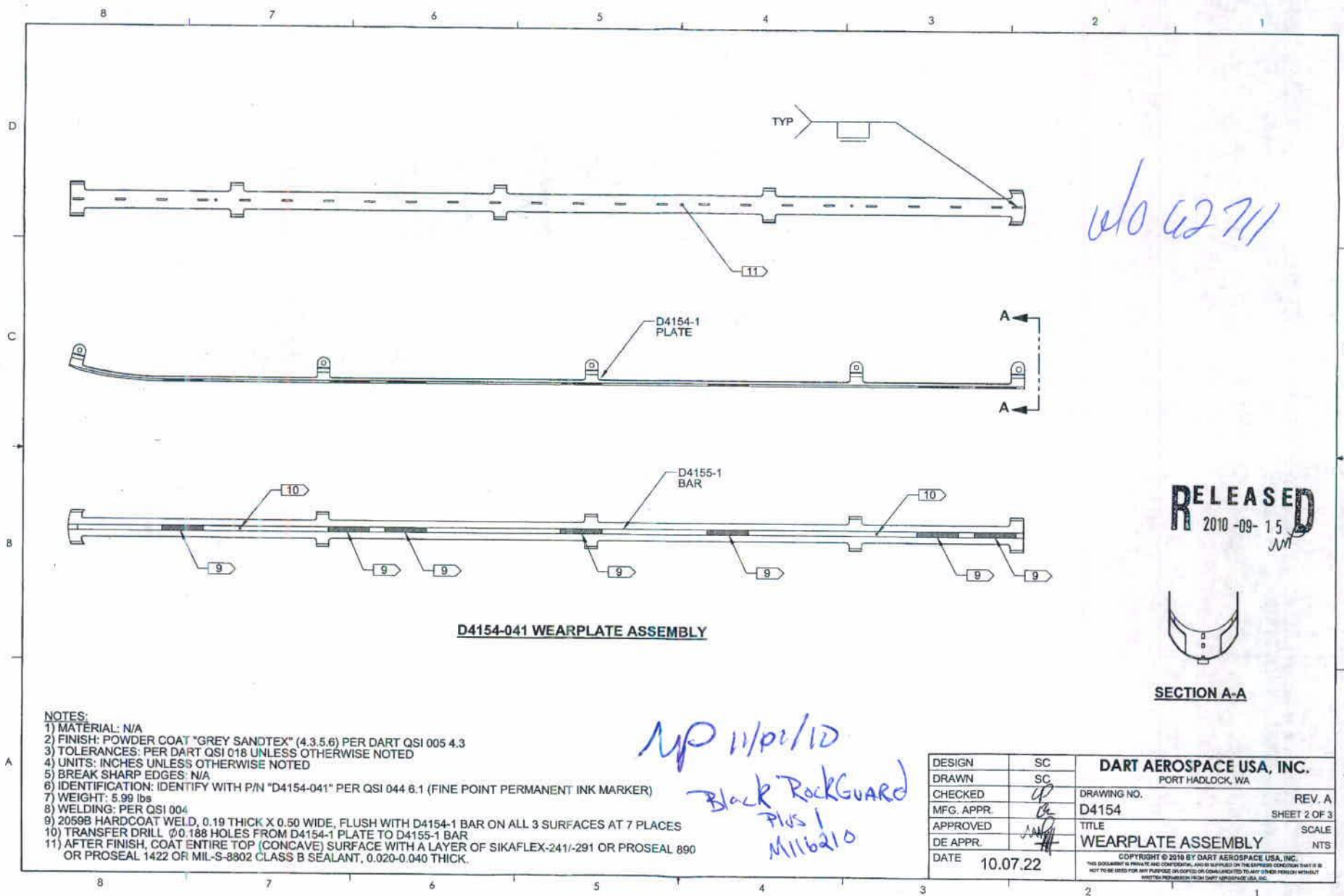
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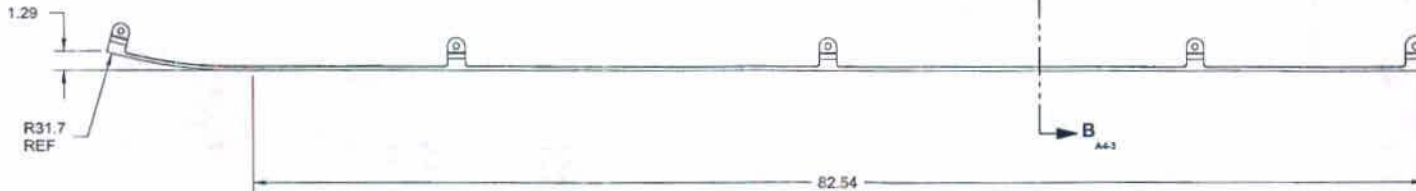
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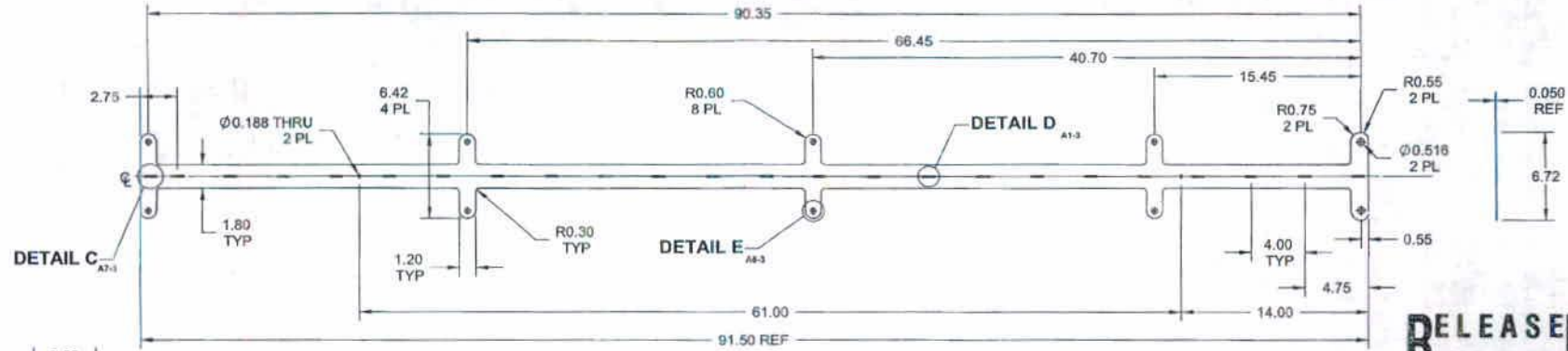
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



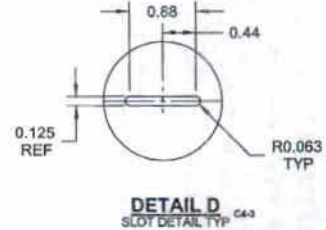
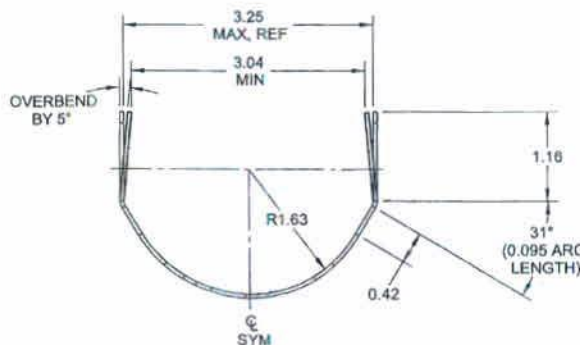
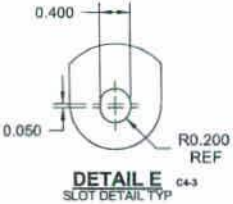
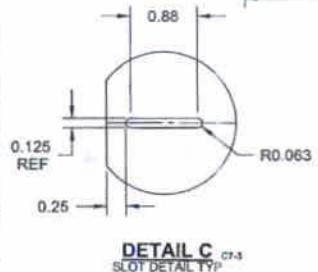
alocory

D4154-1 PLATE
(MAKE FROM D4154-1F)



D4154-1F FLAT PATTEN

RELEASED
2010-09-15
W



- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.71 lbs

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO. D4154	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE WEARPLATE ASSEMBLY	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

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